



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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646.9704

Job Sheet 185022



Part No: 646.9704

Job Qty: 2 ea

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG Rev.E Sheets 1-3&68 IPP Rev.A New issue 18/05/04 JFS Verified by:DD

Ship Via:

6316

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		10/31/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 07 2018
110	Packaging	2 pcs		10/31/18	0.00	0.00	Packaging1-1		NOV 07 2018
120	Small Fab	2 pcs		10/31/18	0.00	0.67	Small Fab-1		
130	QC	2 pcs		10/31/18	0.00	0.00	QC5		
140	Packaging	2 pcs		10/31/18	0.00	0.00	Packaging3-1		
150	QC21-SA	2 Ea		10/31/18	0.00	0.00	QC21		NOV 08 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note .
Descriptions: 140 - ***IDENTIFY AS PER IAW MPP-120***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9711	Blade	4 Ea (2 ea)	90-Start up Operation	5050304
MS21042L08	Nut	12 Ea (6 ea)	90-Start up Operation	5100409
MS27039-08-19	Screw	12 Ea (6 ea)	90-Start up Operation	5044235
NAS1149FN832P	Washer	24 Ea (12 ea)	90-Start up Operation	5100408
646.9714	Body			5123064

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.9711	4	131	0
	MS21042L08	12	2,071	0
	MS27039-08-19	12	1,807	0
	NAS1149FN832P	24	2,949	0



Container No: S125383



Part: 646.9704

Job No: 185022

Serial No/Batch: S125383

Revision: E

Inspector:

Exp Date:

Instructions:

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10/22/18 8:59 AM Dart.lajeunesse.marie

Date: 11/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					